

Work Order ID 58268

May 3, 2010 9:51:49 AM



Page 2

Item ID: D2939-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle RH In, 206

Start Date: 03/05/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 13/05/2010 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

amk 10/05/24

5

QC

Memo

0.00

STP 10/05/21

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

20 10/05/25

5 0

HandFinish

Memo

0.00

Hand Finishing

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

20 10/06/20

5 0

Powdercoat

Memo

0.00

Powder Coating

START TIME: *9:00pm* FINISH TIME: *9:20pm* OVEN TEMPERATURE: *320F*

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Page 3

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Item Name: Saddle RH In, 206

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Process Plan:

Date:

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Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

~~10-5-25~~ 10-5-25

170

Identify as per dwg & Stock Location: 428A

0.00



Packaging

Memo

0.00

Packaging

10-5-25 10-5-25

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/26 10/05/26

Picklist Print

May 3, 2010 9:51:53 AM

Page 1

Work Order ID: 58268



Parent Item: D2939-2



Parent Item Name: Saddle RH In, 206

Start Date: 03/05/2010

Required Date: 13/05/2010

Comments: IPP: B 00.06.26 New DWG rev (mpp 2069) EC
IPP Rev:C As per Rev C 07-03-19 JLM

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D6101-001		Manufactured	No			100	Each	82.0000	1			



Saddle Billet



Location	Loc Qty	Loc Code
MAT	40	
	40	
MAT40	42	
	42	

6 + 1 2.8 10/05/21

DART AEROSPACE LTD				Work Order:	58268
Description: 206 Saddle, Inboard, Right side				Part Number:	D2939-2
Inspection Dwg: D2939 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	13	24	35
A	0.100	0.140		.135	.134	.131	.128	.128
B	0.100	0.140		.130	.130	.127	.125	.123
C	0.100	0.140			.110	.110	.112	.108
D	0.210	0.230		.220	.225	.225	.228	.228
E	1.245	1.255			1.250	1.250	1.250	1.250
F	1.245	1.255			1.250	1.250	1.250	1.250
G	2.495	2.505			2.500	2.500	2.500	2.500
H	0.510	0.515			.511	.512	.512	.512
I	1.572	1.582		1.578	1.578	1.578	1.578	1.578
J	2.495	2.505		2.500	2.500	2.500	2.500	2.500
K	0.257	0.262		.259	.259	.259	.259	.259
L	0.312	0.317			.314	.314	.315	.315
M	0.235	0.240			.236	.236	.235	.234
N	0.100	0.140		.110	.111	.112	.112	.112
O	0.540	0.560		.542	.551	.551	.552	.553
P	0.490	0.510			.500	.500	.492	.503
Q	3.715	3.725		3.720	3.720	3.720	3.720	3.720
R	2.720	2.760		2.744	2.744	2.744	2.744	2.744
S	0.240	0.270		.254	.253	.253	.254	.252
T	0.100	0.180		.133	.140	.133	.133	.133
U	1.625	1.635		1.631	1.631	1.631	1.631	1.631
V	1.362	1.372		1.368	1.368	1.368	1.363	1.368
W	0.316	0.321		.317	.317	.316	.316	.316
X	1.250	1.270		1.259	1.261	1.256	1.260	1.259
Y	1.565	1.585		1.575	1.576	1.570	1.575	1.570
Z	0.178	0.198		.183	.183	.188	.189	.188
AA								
AB								
AC								
AD								

Accept/Reject **SCRAP**

Measured by: <i>[Signature]</i>	Date: 10/05/21
Audited by: <i>[Signature]</i>	Date: 10/05/21
Prototype Approval: N/A	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	
D	07.11.23	DT8695 A/B removed	KJ/EC/DD	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order:	58768
Description: 206 Saddle, Inboard, Right side		Part Number:	D2939-2
Inspection Dwg: D2939 Rev: C DSK: Rev:		Page 1 of 1	

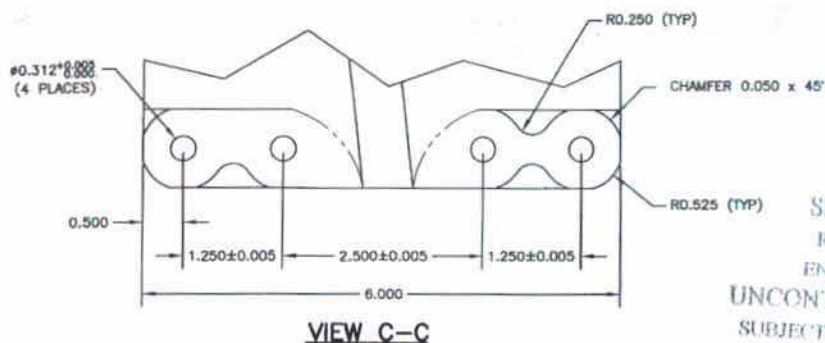
FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

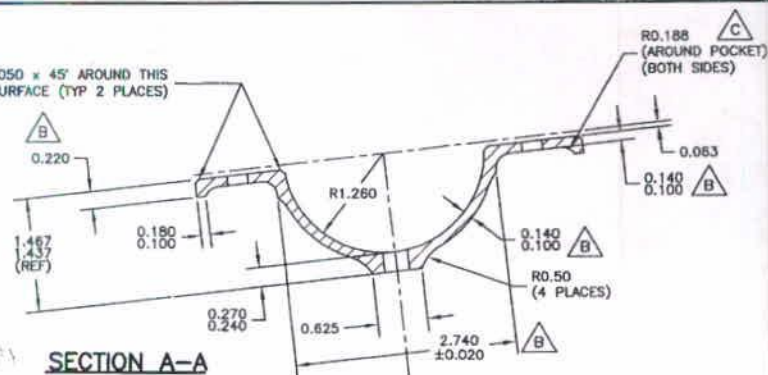
Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				4	5	6	7	8
A	0.100	0.140		.127	.127			
B	0.100	0.140		.138	.125			
C	0.100	0.140		.104	.104			
D	0.210	0.230		.228	.227			
E	1.245	1.255		1.250	1.250			
F	1.245	1.255		1.250	1.250			
G	2.495	2.505		2.500	2.500			
H	0.510	0.515		.512	.512			
I	1.572	1.582		1.578	1.578			
J	2.495	2.505		2.500	2.500			
K	0.257	0.262		.259	.259			
L	0.312	0.317		.312	.312			
M	0.235	0.240		.235	.236			
N	0.100	0.140		.112	.112			
O	0.540	0.560		.550	.550			
P	0.490	0.510		.496	.497			
Q	3.715	3.725		3.720	3.720			
R	2.720	2.760		2.740	2.740			
S	0.240	0.270		.251	.250			
T	0.100	0.180		.132	.132			
U	1.625	1.635		1.623	1.623			
V	1.362	1.372		1.363	1.363			
W	0.316	0.321		.317	.317			
X	1.250	1.270		1.268	1.265			
Y	1.565	1.585		1.581	1.578			
Z	0.178	0.198		.183	.188			
AA								
AB								
AC								
AD								
Accept/Reject								

Measured by:	RF/MWF 10/05/24	Date:	10/05/21
Audited by:	One	Date:	10/05/24
Prototype Approval:	N/A	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	
D	07.11.23	DT8695 A/B removed	KJ/EC/DD	



CHAMFER 0.050 x 45° AROUND THIS SURFACE (TYP 2 PLACES)



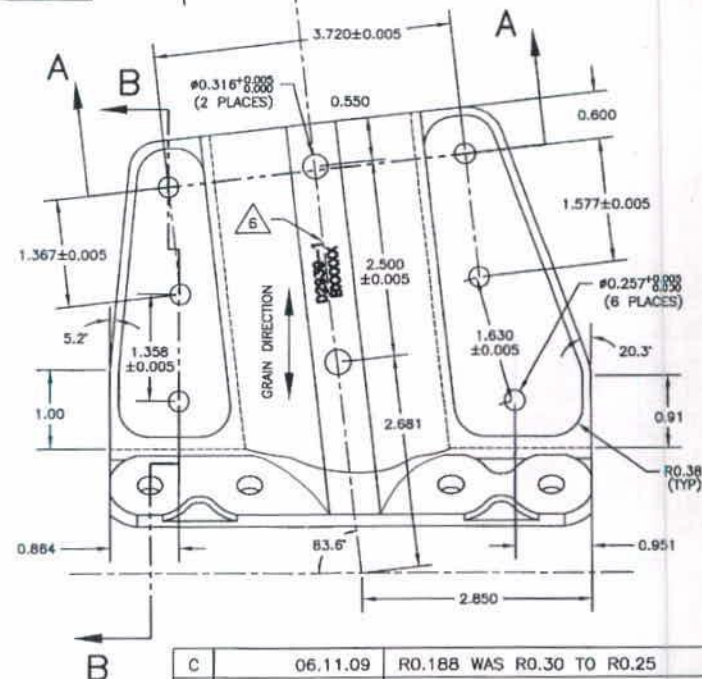
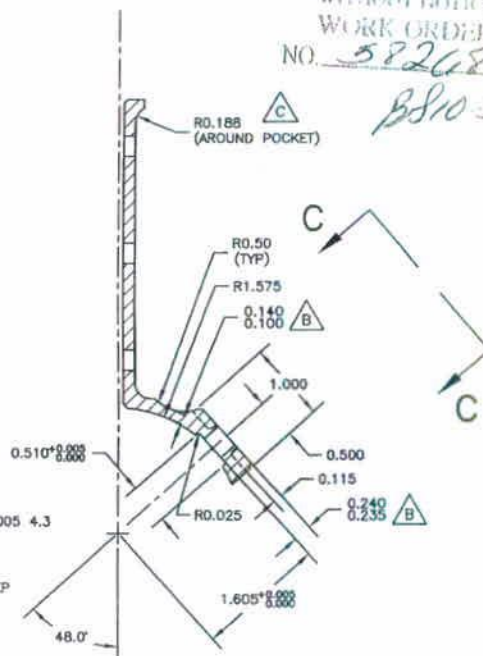
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WORK ORDER
NO. 58268

BS10503

D2939-1 LH SADDLE (SHOWN)
D2939-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED DEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC.
CHECKED	APPROVED	DRAWING NO. D2939
DATE	06.11.09	TITLE SADDLE INSIDE

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REV. C
SHEET 1 OF 1
SCALE
2:3